

Work Order ID 110021

December-17-13 9:06:19 AM

110021

Page 1

Item ID: D412-742-043

Revision ID:

Item Name: Replacement Skidtube (Fits LH or RH) High Gear Apical Tri-Bag Float Compatible

Start Date: 12/17/13 Start Qty: 1.00 *1*

Required Date: 12/17/13 Req'd Qty: 1.00 *1*

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals:

Process Plan: 

Date: 12-12-13

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3391

I

100

0.00

100

DC

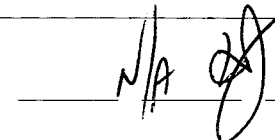
Document Control

DOCUMENT CONTROL

Memo

If D412-742-043 is a W/O on it's own,
Photocopy bluefile and create labels per PPP D412-742-043 CHG005

0.00



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Page 2

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Required Date: 12/17/13 Req'd Qty: 1.00 *1*

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____

QC: _____ Date: _____

Tooling: _____ Date: _____

SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center ID

110

110

HandFinish

Hand Finishing

Operation
Description

HandFinishing

Memo

1-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle holes for proper alignment. using 7/16" "T" Pins.
A/RSikaflex-241/-291 13 128659
Expiry date: 1410

2-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Seal all bolts with sikaflex except ones with inserts on inside of tube, hand tighten only bolts with no sikaflex.

A/RSikaflex-241/-291 11 28659
Expiry date: 1410

3-Remove "T" pins once sikaflex is dry.

4-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser.
A/RLPS Procyon 11 122900

Set Up/
Run Hours

0.00

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

1x f ll 110402

Work Order ID 110021

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Item ID: D412-742-043

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

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Start Date: 12/17/13 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 12/17/13 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

Quality Control

0.00

130

Packaging

0.00

130

Packaging

Memo

Packaging

Identify and pack for shipping as per PPP D412-742-043

Location: _____

PPP Rev: _____

PPP 112119

0.00

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

Quality Control

0.00

1

1 8 14-04-9

14/4/9

14-04-09

Picklist Print

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Work Order ID: 110021

Parent Item: D412-742-043

Parent Item Name: Replacement Skidtube (Fits LH or RH) High Gear Apical Tri-Bag Float Compatible

Start Date: 12/17/13

Required Date: 12/17/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev A 05.10.13 New Issue KJ/JLM
 IPP Rev 06.02.13 ECN 773 dwg @ rev.D EC
 IPP Rev:C 07-05-28 As per Rev F JLM
 IPP Rev:D 07-12-04 ECN 1072 DD verified by:JLM
 IPP Rev:E 08-09-08 ecn 08-510 DD verified by:EC
 REV.B DD verified by:EC
 IPP Rev:F 11.11.01 as per DSI9517

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3391-021 Fwd Tube Assembly		Manufactured	No				Each	0.0000		3114510 ¹ (1x) JLM 11/04/102			
D3391-023 Mid Tube Assembly		Manufactured	No			110	Each	0.0000		13114516 ¹ (1x) JLM 11/04/102			
D3391-025 Aft Tube Assembly		Manufactured	No			110	Each	0.0000		13108343 ¹ (1x) JLM 11/04/102			
AN3C4A Bolt		Purchased	No			110	Each	2,966.0000	24	JLM 24 11/04/102			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				FG		20							
				122814		20							
				ST512		44							
				M126765		44							
				ST513		2902							
				125388		1908				X24			
				M127410		994							
AN3C6A Bolt		Purchased	No			110	Each	658.0000	10	JLM 10 11/04/102			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				FG		10				X10			
				122416		10							
				FP001		30							
				122599		30							
				ST350		17							
				122416		17							
				ST513		601							
				m125709		601							

Picklist Print

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Work Order ID: 110021

Parent Item: D412-742-043

Parent Item Name: Replacement Skidtube (Fits LH or RH) High Gear Apical Tri-Bag Float Compatible

Start Date: 12/17/13

Required Date: 12/17/13

Start Qty: 1.00

Required Qty: 1.00

AN3C7A Purchased No 110 Each 910.0000 4 4 12/10/13

Bolt

Location Loc Qty Loc Code

FG 10

122141 10

ST351 10

123900 6

124221 4

ST513 890

m125709 890

NAS1149C0332R

Purchased No

110 Each 10,701.000

38 38 12/10/13

WASHER

Location Loc Qty Loc Code

FP001 254

123355 254

GA 1548

125654 1548

ST292 119

123248 18

123759 10

125268 91

st510 8654

m126319 3154

m127306 2500

m127410 3000

ST517 126

124580 126

D4095-041

Manufactured No

110 Each 12.0000

1 1 12/10/13

Wearplate Assembly

Location Loc Qty Loc Code

FP002 12

108286 2

109667 10

B112409

1

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Shop Packet Print

Page 2

Picklist Print

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Start Date: 12/17/13

Required Date: 12/17/13

Start Qty: 1.00

Required Qty: 1.00

D4095-043 Manufactured No 110 Each 3.0000
Wearplate Assembly

1 1 1 1

Location Loc Qty Loc Code

FP002 3 B111932
106162 2
109668 1

1 1 1 1

D4095-045 Manufactured No 110 Each 16.0000
Wearplate Assembly

1 1 1 1

Location Loc Qty Loc Code

FP002 16
108288 1
109669 11
77737 1
84081 1
93054 2

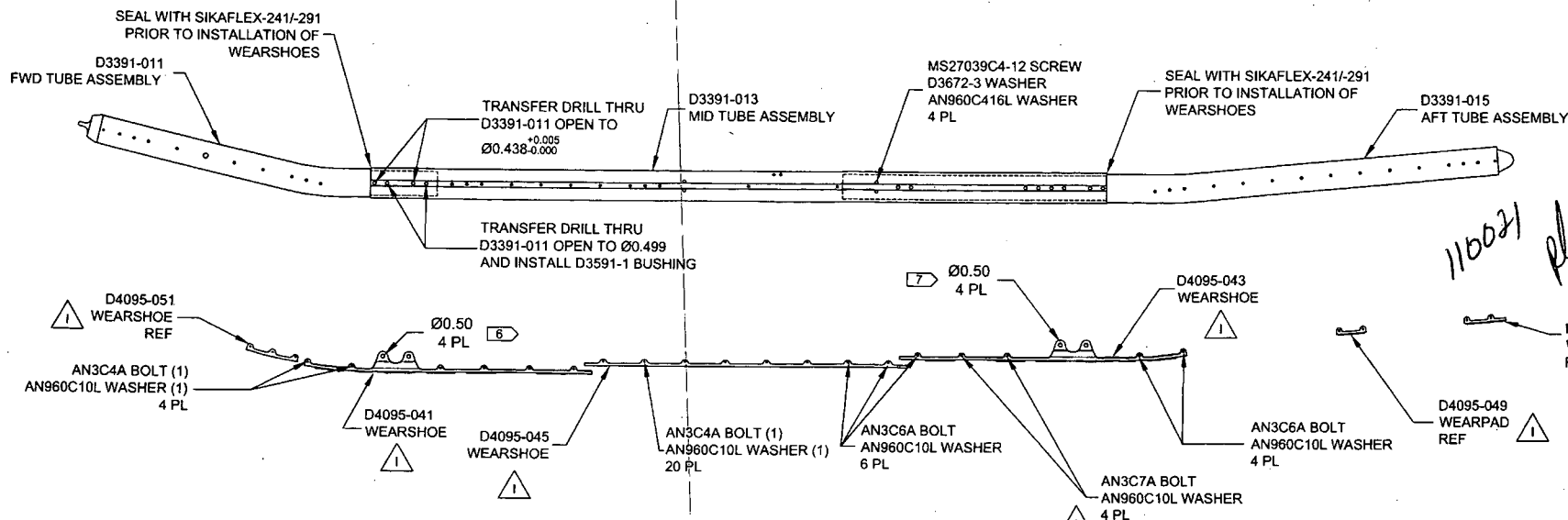
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Shop Packet Print

Page 3



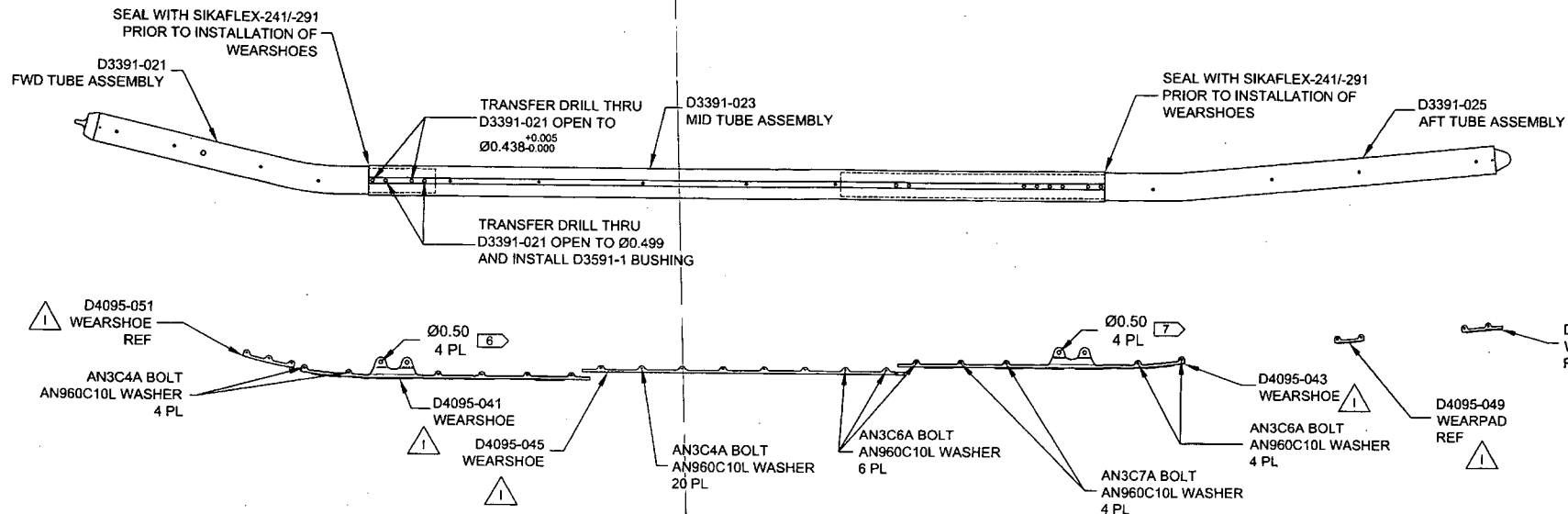
D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
4	D3672-3	WASHER
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARPAD
1	D4095-049	WEARPAD
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON"
AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES
FOR WEARSHOE INSERTS. C-BORE AS NOTED AND INSTALL INSERTS EXCEPT
WHERE INDICATED.
- 6) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH
APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND
TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-041
- 7) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH
THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND
TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-043

I	REMOVE GASKETS AND REPLACE ALL WEARSHOES; PARTS LIST UPDATE, ZN A8-1, ZN A8-2, ZN A6-4, ZN B6-8; LPS-3 COATING REMOVED FROM NOTE 2, ZN A3-1, ZN A3-2, REMOVED INSERT AELS-1032-130, ZN B6-4, B2-4, C7-8, C3-8; REMOVED HOLES, ZN D6-4 ZN D2-4, ZN D7-8, ZN D3-8	XDF	11.10.13
H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL. ADDED D3591-1 BUSHING, ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL. ADDED D3591-1 BUSHING, ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC KENT, WA	
DRAWN	XDF		
CHECKED		DRAWING NO.	REV. I
MFG. APPR.		D3391	SHEET 1 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	11.10.13	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

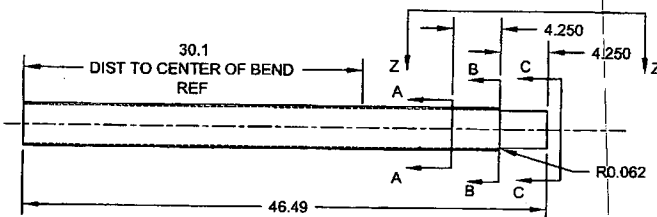
QTY -043	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARSHOE
1	D4095-049	WEARPAD
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER

GENERAL NOTES

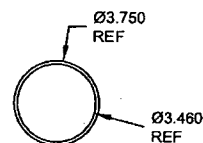
- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.
- 6) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-041
- 7) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-043

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2011-11-04

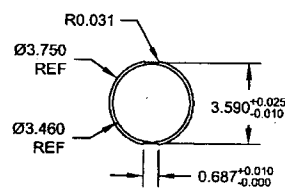
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DRAWN	XDF	KENT, WA	
CHECKED		DRAWING NO.	REV.
MFG. APPR.		D3391	SHEET 2 OF 8
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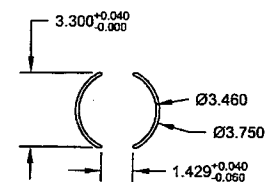
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



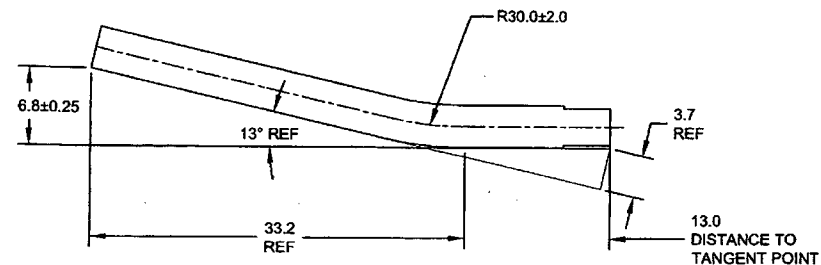
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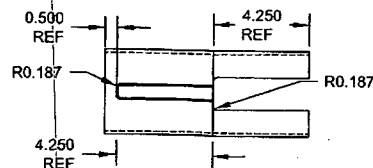
SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X



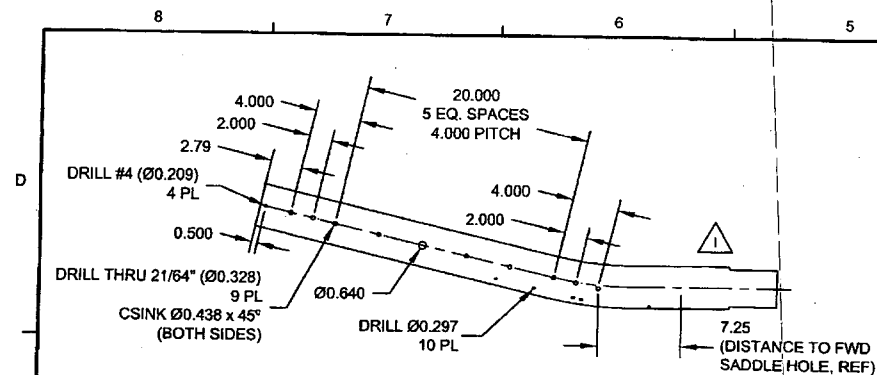
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



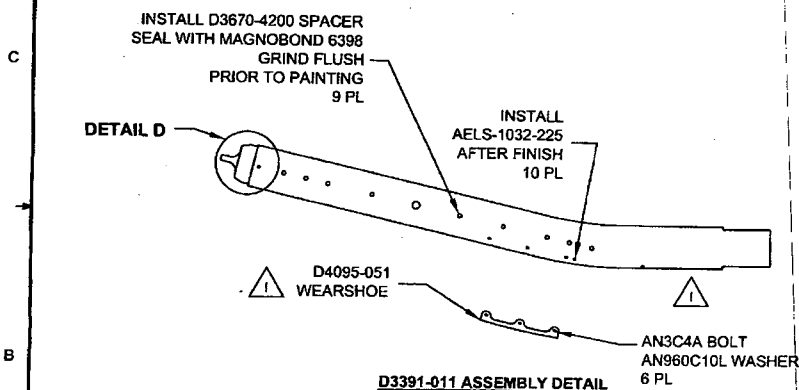
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2011-11-04

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MFG. APPR.		D3391	SHEET 3 OF 8
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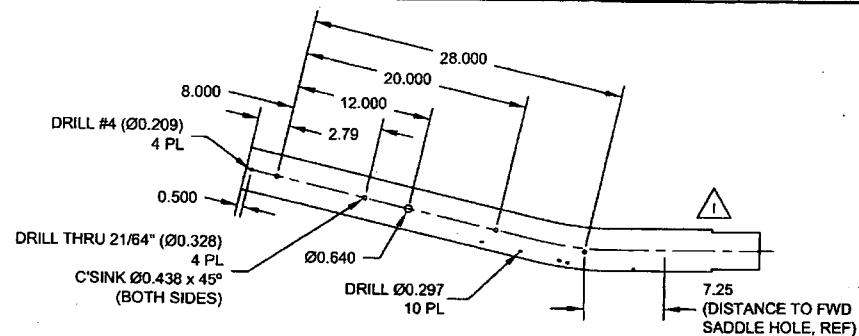
D3391-011 DRILLING DETAIL



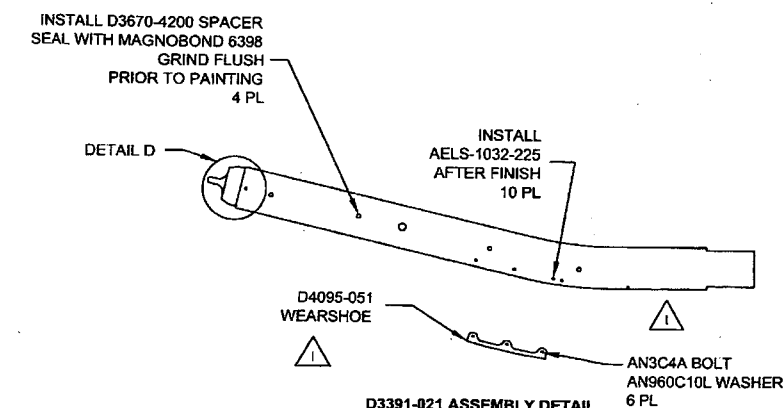
D3391-011 ASSEMBLY DETAIL

D3391-011/-021 FWD TUBE ASSEMBLY PARTS LIST

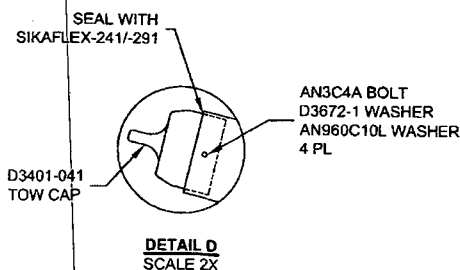
QTY - 011	QTY - 021	PART NUMBER	DESCRIPTION
X		D3391-011	FWD TUBE ASSEMBLY
	X	D3391-021	FWD TUBE ASSEMBLY
1	1	D3401-041	TOW CAP
9	4	D3670-4200	SPACER
4	4	D3672-1	WASHER
1	1	D4095-051	WEARSHOE
1	1	D6013-047	FWD TUBE
10	10	AN3C4A	BOLT
10	10	AN960C10L	WASHER
10	10	AELS-1032-225	INSERT



D3391-021 DRILLING DETAIL



D3391-021 ASSEMBLY DETAIL

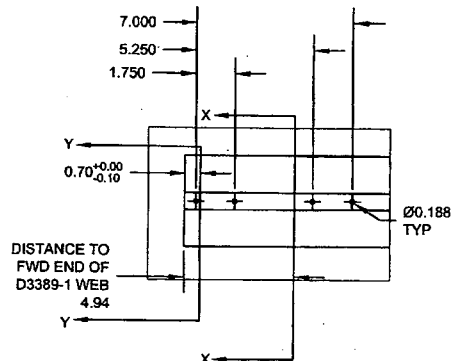


**DETAIL D
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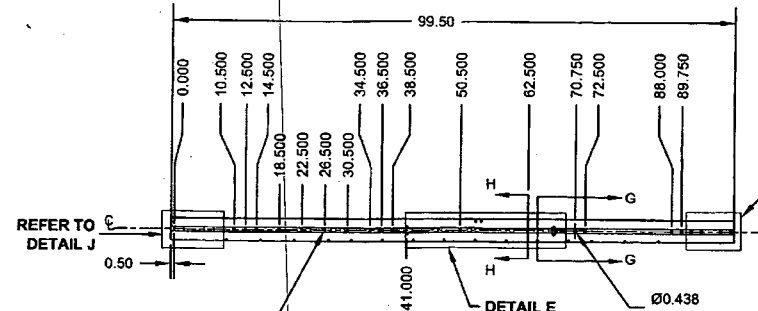
RELEASED
2011-11-04

DESIGN	PH	DART AEROSPACE USA, INC	
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CHECKED		DRAWING NO.	REV. 1
MFG. APPR.		D3391	SHEET 4 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	11.10.13	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC	
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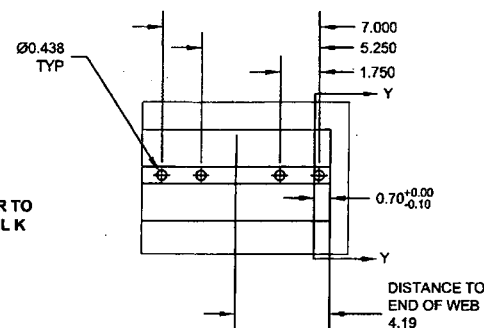
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DETAIL J
SCALE 4X



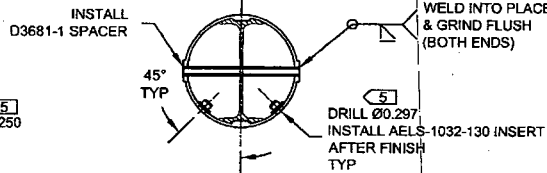
D3391-013 ASSEMBLY DETAIL



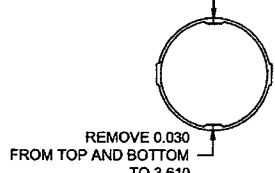
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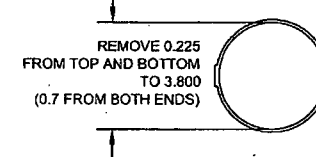
SECTION G-G
SCALE 5X



SECTION H-H
SCALE 5X



SECTION X-X
SCALE 5X



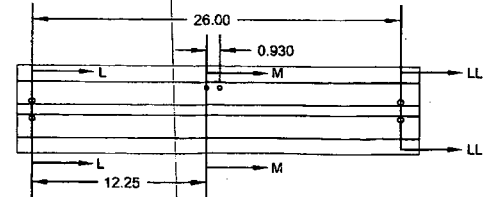
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D3391-013 MID TUBE ASSEMBLY PARTS LIST

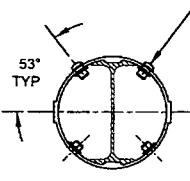
QTY -013	PART NUMBER	DESCRIPTION
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-03	SCREW
4	MS27039C4-08	SCREW

D3391-013 MID TUBE ASSEMBLY

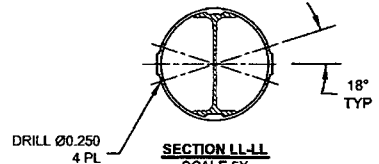
- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART.QSI 004



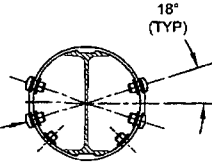
DETAIL E
SCALE NONE



SECTION M-M
SCALE 5X



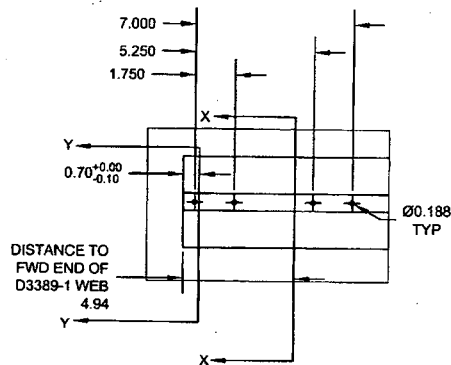
SECTION LL-LL
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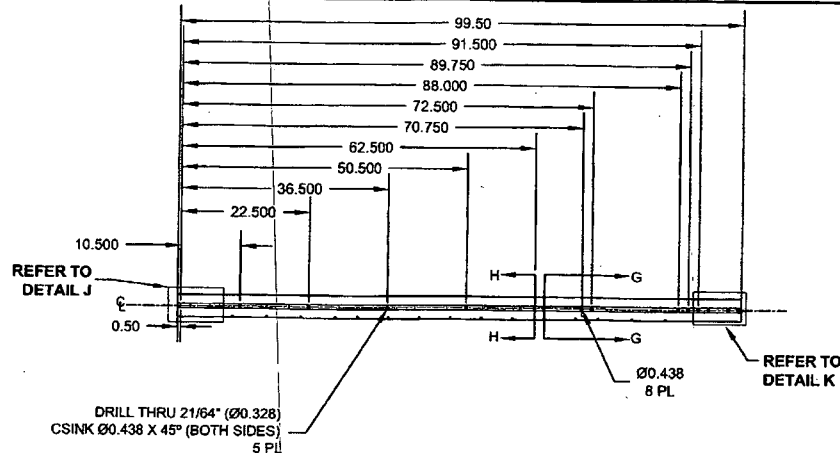
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SCALE 5X

RELEASED
11-11-04

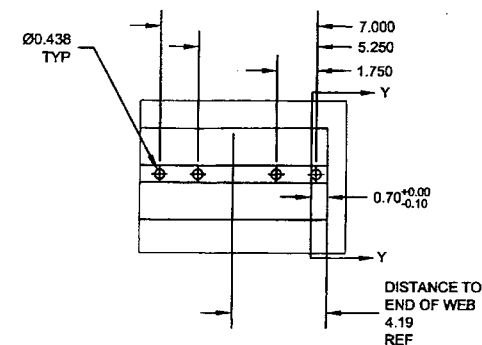
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED		DRAWING NO.	REV. 1
MFG. APPR.		D3391	SHEET 5 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
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DETAIL J
SCALE 4X



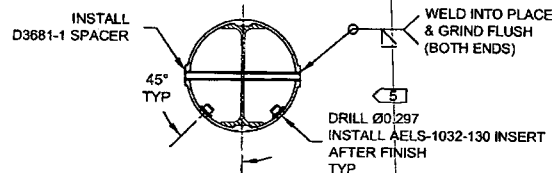
D3391-023 ASSEMBLY DETAIL



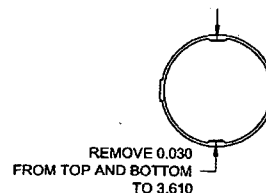
DETAIL K
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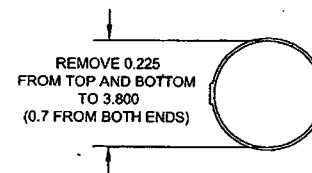
SECTION G-G
SCALE 5X



SECTION H-H
SCALE 5X



SECTION X-X
SCALE 5X



SECTION Y-Y
SCALE 5X

D3391-023 MID TUBE ASSEMBLY PARTS LIST

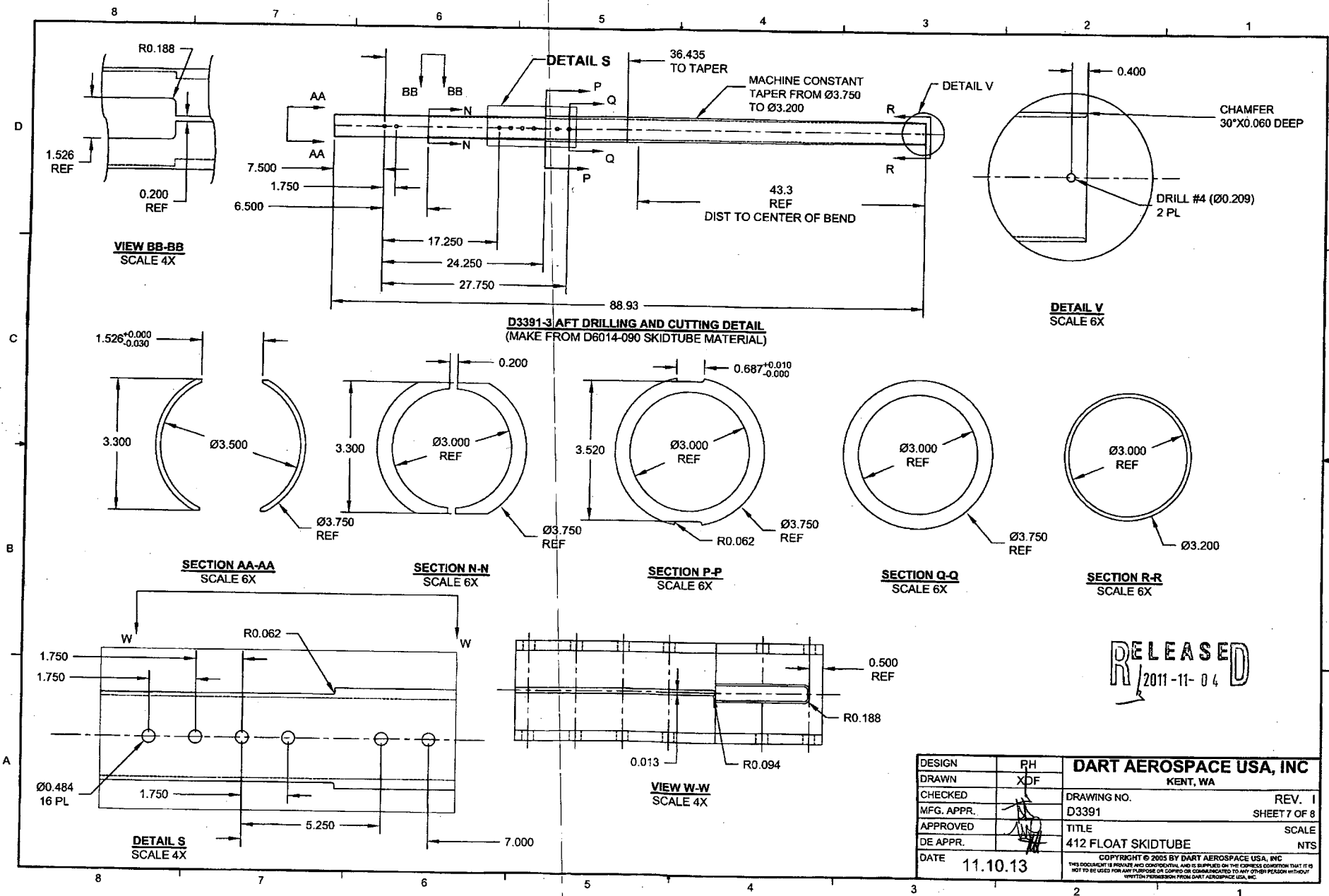
QTY - 023	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

D3391-023 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015
- 3) WELDING: PER DART QSI 004

RELEASED
2011-11-04

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